

Date: Wednesday, 02/04/2008 11:27:35 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: GUIDE		
Job Number	: 38299		Part Number	: D35711		
Estimate Number	: 12687		Drawing Number	: D3571 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 02/04/2008	S.O. No. :	Drawing Revision	: A		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type :	MACHINED PARTS	Due Date	: 14/04/2008 Qty: 20 Um: Each	
Previous Run	: 38086					
Written By	:					
Checked & Approved By	: <u>JL</u> 08.04.08					
Comment	: Est Rev:A New Issue 07-02-01 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6B0750X01500	6061-T6 Bar .75" X 1.5"		
	Comment: Qty.: 0.2531 f(s)/Unit Total : 5.0610 f(s) 6061-T6 Bar .75" X 1.5" Batch: <u>M104Y326</u>		<u>SD</u>	
2.0	BAND SAW	BAND SAW		
	Comment: BAND SAW Cut blank 2.90 " long		<u>SD</u>	<u>08/04/05</u> <u>20</u>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
	Comment: HAAS CNC VERTICAL MACHINING #1			<u>PAW</u>
	1- Mill as per Folio FA675Rev: <u>A</u> & Dwg D3571 Rev: <u>A</u>			
	2-Deburr per dwg D3571		<u>SD</u>	<u>08/04/05</u> <u>15</u> <u>10</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		<u>SD</u>	<u>08/04/05</u> <u>19</u>
5.0	QC8	SECOND CHECK		
	Comment: SECOND CHECK			<u>SD</u> <u>08/04/06</u> <u>19</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3571-1 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes No DQA: D Date: 08/04/15  
 D412-702 QA: N/C Closed: D Date: 08/04/15

NCR: 38299		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/05	3.0	-1 part scrap. C-sink offset by .030. Programming error	08/04/05	Fix Program  Scrap and Destroy and replace part	08/04/05	08/04/05	08/04/05	08/04/05
				no more				

NOTE: Date & initial all entries

Date: Wednesday, 02/04/2008 11:27:35 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 38299

Part Number: D35711

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Fx 08/04/08 (19)

7.0 POWDER COATING POWDER COATING



M106442



(19X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m-f 08/04/09

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



98

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-04-09

(X19)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

570447 08/04/10 (18)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/14 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-10

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	38299
Description: Guide	Part Number:	D3571-1
Inspection Dwg: D3571      Rev: A		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	SA	Audited by:	SF	Prototype Approval:	N/A
Date:	08/04/05	Date:	08/04/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	SJT

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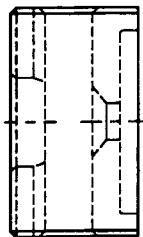
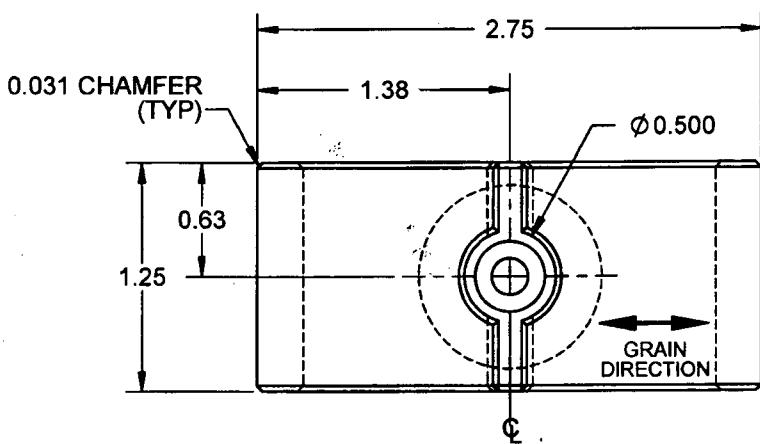
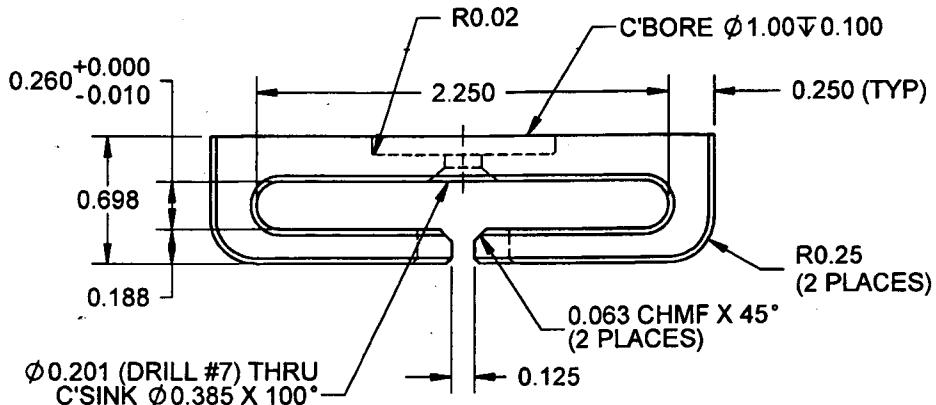
**SUBJECT TO AMENDMENT**

**WITHOUT NOTICE**

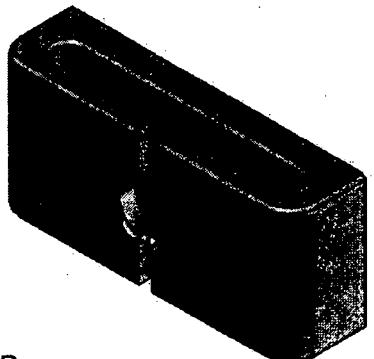
**WORK ORDER**

**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>-H-</i>	DRAWING NO. <b>D3571</b>	REV. A SHEET 1 OF 2
DATE <b>07.01.29</b>		TITLE <b>GUIDE</b>	SCALE 1:1
REV <b>A</b>	DATE <b>07.01.29</b>	DESCRIPTION <b>NEW ISSUE</b>	

**RELEASED**07.04.12 *PH*

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WORK ORDER  
NO. 38299

**D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR  
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116  
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\text{\textcircled{C}}$

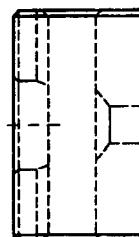
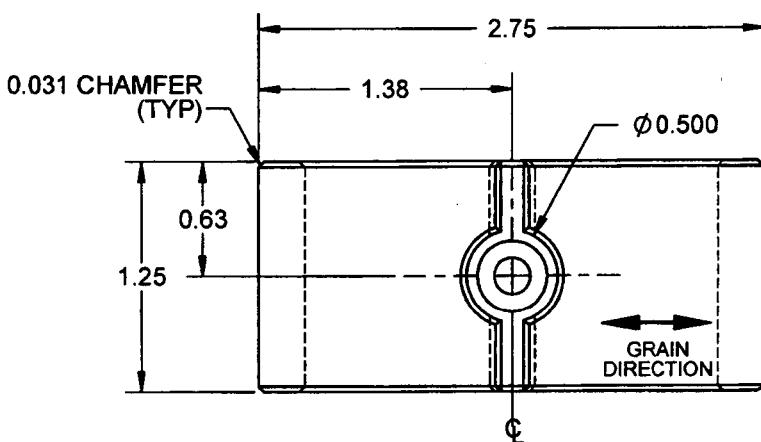
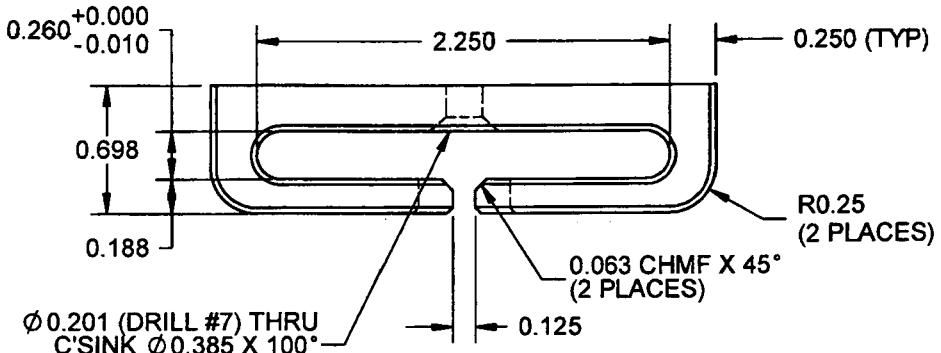
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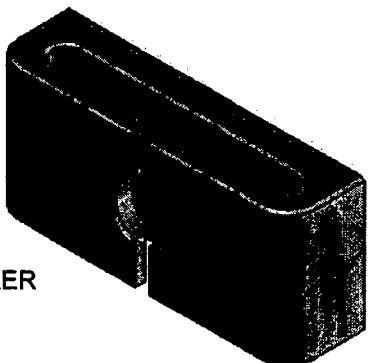
**DART**

DESIGN <i>CE</i>	DRAWN BY <i>CE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JM</i>	DRAWING NO. D3571	REV. A SHEET 2 OF 2
DATE 07.01.29		TITLE GUIDE	SCALE 1:1

RELEASED

07.04.12 *[Signature]*

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NO. 38299

**D3571-3 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-3" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT  $\text{C}$

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